

Date: Wednesday, 06/08/2008 2:05:58 PM
User: Julie Lecocq

Process Sheet

SPLIT

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : REPLACEMENT GLARESHIELD KIT
Job Number : 41017	
Estimate Number : 13307	
P.O. Number :	Part Number : D412776011
This Issue : 06/08/2008 S.O. No. :	Drawing Number : D412-776 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 39207	Material :
Written By :	Due Date : 28/08/2008 Qty: 1/2 Um: Each
Checked & Approved By : JUD 08.8.06	
Comment : Est Rev:A 08.05-12 new issue DD verified by: LL Est Rev:B 08-07-14 revB as per dwg DD verified by:ec	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JUD 08.9.8



Comment: Photocopy bluefile & type labels per PPP D412-776-011 CHG001

500/09/09

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

3.0 D3690041 Glareshield Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Glareshield Assembly
batch: 41207

slaks

12

54

4.0 D3699041 Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Support Assembly
batch: 411019

54

5.0 D3699042 Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Support Assembly
batch: 41020

slaks

54

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 06/08/2008 2:05:59 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT GLARESHIELD KIT

Job Number: 41017

Part Number: D412776011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	AN33A	Bolt
-----	-------	------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

batch:

M109059

18

08/09/02

7.0	AN35A	Bolt
-----	-------	------



Comment: Qty.: 10.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bolt

batch:

M100088

SP

8.0	AN960JD10L	Washer
-----	------------	--------



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Washer

batch:

M104885

SP

9.0	AN960JD6L	Washer
-----	-----------	--------



Comment: Qty.: 11.0000 Each(s)/Unit Total : 22.0000 Each(s)

Washer

batch:

M5519

SP

10.0	AN9703	Washers
------	--------	---------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washers

batch:

M105953

SP

11.0	MS20426AD33	Rivet
------	-------------	-------



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Rivet

batch:

M1563

SP

12.0	MS21042L06	Nut
------	------------	-----



Comment: Qty.: 11.0000 Each(s)/Unit Total : 22.0000 Each(s)

Nut

batch:

M108574

8/8/11

(2x)

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 06/08/2008 2:05:59 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT GLARESHIELD KIT

Job Number: 41017

Part Number: D412776011

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS21075L08

ANCHOR NUT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)

ANCHOR NUT

batch: M108963

14.0

MS35206228

Screw



Comment: Qty.: 11.0000 Each(s)/Unit Total : 22.0000 Each(s)

Screw

batch: M108963

8/8/00

SLP

SLP

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

50868600 (10)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-776-011

Location:

PPP Rev:

DART

8/8/08

①

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/08

Job Completion



U 08.09.08

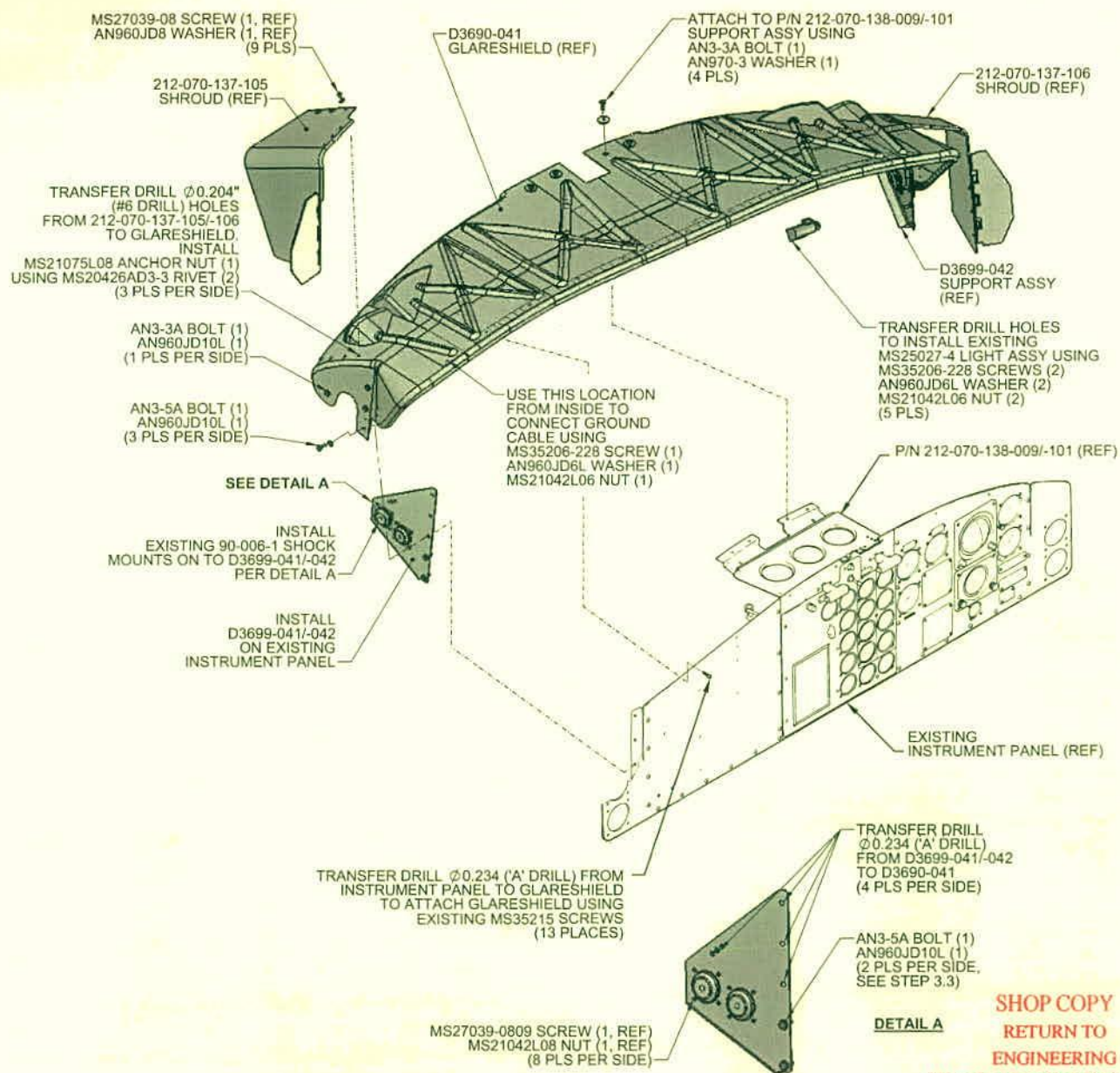
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Proc Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**FIGURE 2: D412-776-011 Replacement Glareshield Kit Installation
(For 212/412 Aircraft using 90-006-1 Shock Mounts)**

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41061

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Revision: **B**
Date: 08.06.24

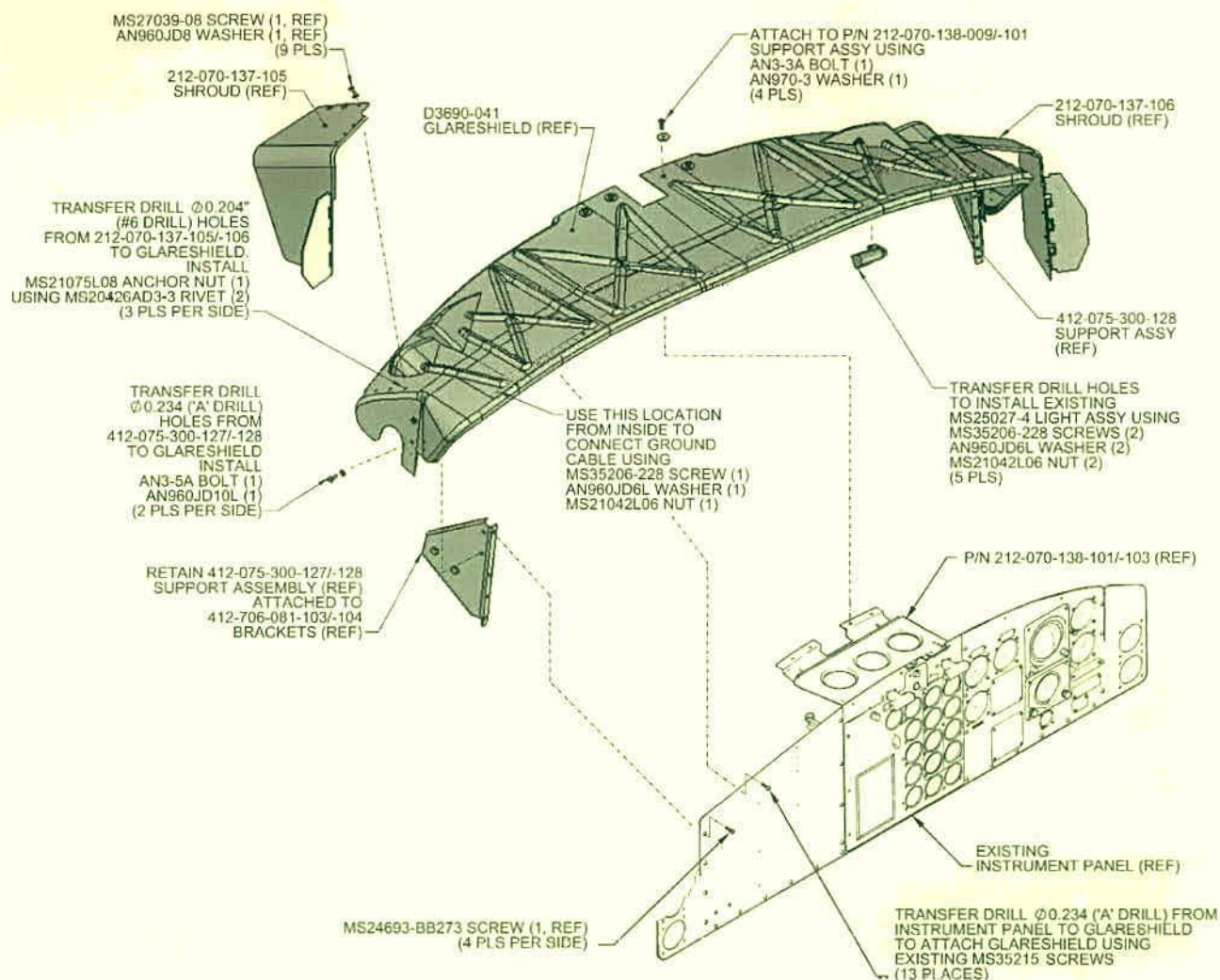


FIGURE 3 : D412-776-011 Replacement Glareshield Kit Installation
(For 212/412 Aircraft NOT using 90-006-1 Shock Mounts)

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 41017

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Revision: **B**
Date: 08.06.24

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4. WEIGHT AND BALANCE

The net weight increase associated with the D412-776-011 Replacement Glareshield Kit is negligible.

5. PARTS LIST

Qty -011	Part Number	Description
X	D412-776-011	REPLACEMENT GLARESHIELD KIT
1	D3690-041	GLARESHIELD ASSEMBLY
1	D3699-041	SUPPORT ASSEMBLY
1	D3699-042	SUPPORT ASSEMBLY
6	AN3-3A	BOLT
10	AN3-5A	BOLT
12	AN960JD10L	WASHER (or NAS1149DN332J)
11	AN960JD6L	WASHER (or NAS1149DN616J)
4	AN970-3	WASHER
12	MS20426AD3-3	RIVET
11	MS21042L06	NUT
6	MS21075L08	ANCHOR NUT
11	MS35206-228	SCREW

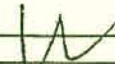
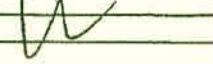
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NO. 41017

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NATURAL HISTORY
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AMERICAN MUSEUM OF
NATURAL HISTORY
1000

OFFICE 6316A

Date: Friday, 03/04/2009 12:40:13 PM
User: Linda Lucello

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D3690-041
Job Number : 46922	
Estimate Number : 10804	
P.O. Number :	Part Number : REWORK35
This Issue : 03/04/2009 S.O. No. :	Drawing Number : REWORK
Prsht Rev. : NC	Project Number :
First Issue : / / Type : THERMOFORMING	Drawing Revision :
Previous Run : 00015	Material :
Written By : 	Due Date : 10/04/2009 Qty: 2 Um: Each
Checked & Approved By : 	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	SPRAY PAINTING	SPRAY PAINTING
-----	----------------	----------------



Comment: SPRAY PAINTING EAGLE:

PULL FROM STOCK:

1 X D412-776-011 (D3690-041) B41017

✓ 1 X D412-776-011 (D3690-041) B41187

EAGLE WO# 45594.1.4

EAGLE WO# 45594.1.5

SAND/SCUFF LIGHTLY TO REMOVE EXISTING PAINT

RE-PAINT PER QSI005 4.2.3

JUN 02 2009

2.0	QC14	INSPECT SPRAY PAINT
-----	------	---------------------



Comment: INSPECT SPRAY PAINT

JUN 02 2009

3.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL / ORDER ENTRY:

~~SEND NEW ARC'S~~

ADD A COPY OF THIS WO TO EACH REWORKED 9-DIGIT

4.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 09.0603



4.2.3 Paint – Glareshield D3690-041

4.2.3.1 The following products are acceptable:

Surface Preparation:

- BASF Glasurit plastic cleaner 541-30

Adhesion Promoter:

- BASF 865 adhesion promoter (preferred)

Sealant:

- BASF transparent filler 285-60 : Mix the sealer as follows :
 - Add 2 parts of 285-60
 - Add 1 part of 929-53
 - Add 30% by mixed volume of 352-50 reducer
 - Stir and let settle for 10 minutes

Topcoat:

- BASF Glasurit 22-Line, urethane flat Dart black, color code SFA39.50 (CSO: custom mix) paint. Ensure the color is a CSO mix, and mixed as follows.

Note a per gallon ratio is exemplified:

	<u>Individual Quantity</u>	<u>Cumulative Quantity</u>
• M0	187.10g	187.10g
• M26	946.80g	1133g
• M5	30.40g	1164g
• M6	8.10g	1172.4g
• M60	33.50g	1205.9g
• 522-300	2508.20g	3714.1g
• Totalling	3714.10g	

- Ensure to mix the SFA39.50 as follows to achieve the correct mixing for spraying, and for the proper final finish:
 - Add 3 parts SFA39.50 flat black
 - Add 1 part 929-91 activator
 - Add 20% by mixed volume of 352-50 reducer
 - Stir and let settle for 10 minutes

4.2.3.2 Surface Preparation:

- The surface must first be cleaned using BASF Glasurit 541-30. Evenly wash all surfaces and corners using a clean soft lint free rag, followed by a dry clean soft lint free rag.
- Ensure the part surface is no longer slick to the touch. If the surface is still slick, repeat.
- Evenly dry sand the painted surface using a 400 to 600 grit dry paper or a maroon 3M scotchbrite pad. Ensure all corners and edges are scuffed for proper adhesion, until gloss finish has been removed, and there are no burrs on the surface or edges caused by sanding.
- Blow off any dust or sanding particles.
- Clean the surface to be painted using BASF Glasurit 541-30 as noted above.

Eagle Copters Maintenance Ltd

WORK REPORT

Work Order Number: 45594

Dart General Shop

This Work Report forms part of this aircraft's permanent technical records - DO NOT DESTROY.

Squawk: 1.5

Discrepancy:

Repaint Glareshield p/n D412-776-011 b/n 41187 (installed on C-FZQB) per QSI 005 section 4.2.3

Resolution:

Glareshield p/n D412-776-011 b/n 41187 (installed on C-FZQB) repainted per QSI 005 section 4.2.3

1.5 Work Done By: Ken Moore

The maintenance described above has been performed in accordance with the applicable standards of airworthiness.
AMO 6-81 Signature: Dan Lemay on 5/25/2009

Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
-----	-------------	---------------	------------------	---------------------

Squawk: 1.6

Discrepancy:

Develop Aft Cabin Wall Protectors

Resolution:

See Squawk 1.11

1.6 Work Done By: Dan Lemay

Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
-----	-------------	---------------	------------------	---------------------

Squawk: 1.8

Discrepancy:

Modify RH spacepod for installation on EC130

Resolution:

1.8 Work Done By:

Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
-----	-------------	---------------	------------------	---------------------

Squawk: 1.9

Discrepancy:

Prepare NOS for baggage compartment protectors for testing. See Harvey.

Resolution:

1.9 Work Done By:

Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
-----	-------------	---------------	------------------	---------------------

Squawk: 1.10

Discrepancy:

Install baggage compartment protectors in C-FNOS tailboom baggage compartment per IIN-D412-760 Section 3.7

Resolution:

Baggage compartment protectors installed per IIN-D412-760 Section 3.7

1.10 Work Done By: Jason Chanthvong

The maintenance described above has been performed in accordance with the applicable standards of airworthiness.
AMO 6-81 Signature: Colin Gould on 5/12/2009

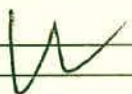
Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
-----	-------------	---------------	------------------	---------------------

***** Original Maintenance Releases and Independent Control Inspection details are stored electronically at *****
***** Eagle Copters Maintenance Ltd. in Calgary Alberta in the Corridor Software *****

Date: Friday, 03/04/2009 12:40:13 PM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D3690-041
Job Number	: 46922		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: REWORK35
This Issue	: 03/04/2009 S.O. No. :	Drawing Number	: REWORK
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : THERMOFORMING	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	: 	Due Date	: 10/04/2009 Qty: 2 Um: Each
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	SPRAY PAINTING	SPRAY PAINTING
-----	----------------	----------------



Comment: SPRAY PAINTING EAGLE:

PULL FROM STOCK:

1 X D412-776-011 (D3690-041) B41017

1 X D412-776-011 (D3690-041) B41187

SAND/SCUFF LIGHTLY TO REMOVE EXISTING PAINT

RE-PAINT PER QSI005 4.2.3

2.0	QC14	INSPECT SPRAY PAINT
-----	------	---------------------



Comment: INSPECT SPRAY PAINT

3.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL / ORDER ENTRY:

SEND NEW ARC'S

4.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion





4.2.3 Paint – Glareshield D3690-041

4.2.3.1 The following products are acceptable:

Surface Preparation:

- BASF Glasurit plastic cleaner 541-30

Adhesion Promoter:

- BASF 865 adhesion promoter (preferred)

Sealant:

- BASF transparent filler 285-60 : Mix the sealer as follows :
 - Add 2 parts of 285-60
 - Add 1 part of 929-53
 - Add 30% by mixed volume of 352-50 reducer
 - Stir and let settle for 10 minutes

Topcoat:

- BASF Glasurit 22-Line, urethane flat Dart black, color code SFA39.50 (CSO: custom mix) paint. Ensure the color is a CSO mix, and mixed as follows.
Note a per gallon ratio is exemplified:

	<u>Individual Quantity</u>	<u>Cumulative Quantity</u>
• M0	187.10g	187.10g
• M26	946.80g	1133g
• M5	30.40g	1164g
• M6	8.10g	1172.4g
• M60	33.50g	1205.9g
• 522-300	2508.20g	3714.1g
• Totaling	3714.10g	

- Ensure to mix the SFA39.50 as follows to achieve the correct mixing for spraying, and for the proper final finish:
 - Add 3 parts SFA39.50 flat black
 - Add 1 part 929-91 activator
 - Add 20% by mixed volume of 352-50 reducer
 - Stir and let settle for 10 minutes

4.2.3.2 Surface Preparation:

- The surface must first be cleaned using BASF Glasurit 541-30. Evenly wash all surfaces and corners using a clean soft lint free rag, followed by a dry clean soft lint free rag.
- Ensure the part surface is no longer slick to the touch. If the surface is still slick, repeat.
- Evenly dry sand the painted surface using a 400 to 600 grit dry paper or a maroon 3M scotchbrite pad. Ensure all corners and edges are scuffed for proper adhesion, until gloss finish has been removed, and there are no burrs on the surface or edges caused by sanding.
- Blow off any dust or sanding particles.
- Clean the surface to be painted using BASF Glasurit 541-30 as noted above.



4.2.3.3 Adhesion Promoter:

- Prepare the adhesion promoter as per manufacturer's instructions.
- Apply one even coat over the entire part and allow a flash time of 20 minutes.
- Apply sealer per section 4.2.3.4

4.2.3.4 Sealing:

- Prepare the transparent filler sealer as per section 4.2.3.1
- Apply one coat evenly over the surface being painted. Allow approximately 20 minutes flash time before top coating.

4.2.3.5 Topcoat:

- Ensure the SFA39.50 is mixed in accordance with section 4.2.3.1 as it will affect the final finish.
- Apply the topcoat evenly over the parts surface. Ensure the gun regulator is set correctly for paint mixture type.
- Allow paint flash time of 10 minutes before applying the next coat.
- The total film thickness **should not exceed** 4 mils. When the thickness is exceeded, the flexibility of the paint decreases.
- Allow product to harden to the point where it will not be disturbed in further operations (approximately 12 to 15 hours).

L Lacelle

From: Harvey Siemens [hsiemens@dartaero.com]
Sent: April 3, 2009 10:26 AM
To: 'L Lacelle'
Cc: Marty Boyce; Susanne Sheldon
Subject: RE: glareshields

Linda

Please find below the b/n info for the glareshields that were purchased by Eagle Copters Ltd.

Dart B/N	Eagle PO	Eagle Lot #	Eagle WO/SO	Registration/Location
41017	08-002653	08-013737	SO 08-01579	Chile
41017	08-002553	08-014168	WO 44342	C-FNOS/YYC ✓
41185	08-002553	08-014169	WO 42857	C-GLBF/Peru
41187	09-000108	09-000618	WO 45275	C-FZQB/YYC ✓

I have also talked with Marty (Eagle QA) who will be assisting us in gaining Eagle compliance with our re-paint issues.

Eagle will be re-painting the 2 glareshields that are in Calgary. We may need to send replacement ones to the customers in South America to make it right for the other 2.

Regards,

Harvey Siemens

Mechanical Designer
DART Aerospace Ltd.

P: 403-717-0328
F: 403-717-1288
E: hsiemens@dartaero.com
W: www.dartaero.com
M: 1060 McTavish Road NE, Calgary, Alberta, T2E 5G9



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From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Friday, April 03, 2009 7:17 AM
To: 'Harvey Siemens'
Subject: glareshields

Hi Harvey,
How many glareshields are you repainting? I will send you a custom w/o need to know B/N's too pls.

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd

03/04/2009

L Lacelle

From: Marty Boyce [mboyce@eaglecopters.com]
Sent: April 3, 2009 12:34 PM
To: Craig Swayne; Joe Djorganoski
Cc: 'Susanne Sheldon'; 'Harvey Siemens'; 'L Lacelle'; 'Mike Mallon'
Subject: RE: glareshields

Craig and Joe,

In reference to the communication below, please create a squawk in W/O 44342 C-FNOS and W/O 45275 C-FZQB for removal, repaint and reinstall of the DART glareshields. Repaint to be complied with IAW DART STC. New ARC coming for these for our records for correct certification.

DART will be providing a W/O for this to be carried out.

Please let me know when these entries have been made, thanks.



Marty Boyce, AME
Quality Assurance Manager

Ph; 403-250-7370
 Fax; 403-250-7584
 Email; mboyce@eaglecopters.com

From: Harvey Siemens [mailto:hsiemens@dartaero.com]
Sent: Friday, April 03, 2009 8:26 AM
To: 'L Lacelle'
Cc: Marty Boyce; Susanne Sheldon
Subject: RE: glareshields

Linda

Please find below the b/n info for the glareshields that were purchased by Eagle Copters Ltd.

Dart B/N	Eagle PO	Eagle Lot #	Eagle WO/SO	Registration/Location
41017	08-002653	08-013737	SO 08-01579	Chile
41017	08-002553	08-014168	WO 44342	C-FNOS/YYC
41185	08-002553	08-014169	WO 42857	C-GLBF/Peru
41187	09-000108	09-000618	WO 45275	C-FZQB/YYC

I have also talked with Marty (Eagle QA) who will be assisting us in gaining Eagle compliance with our re-paint issues.

03/04/2009

Date: Friday, 03/04/2009 12:40:13 PM
User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D3690-041
Job Number : 46922	
Estimate Number : 10804	
P.O. Number :	Part Number : REWORK35
This Issue : 03/04/2009 S.O. No. :	Drawing Number : REWORK
Prsht Rev. : NC	Project Number :
First Issue : 1/1 Type : THERMOFORMING	Drawing Revision :
Previous Run : 00015	Material :
Written By :	Due Date : 10/04/2009 Qty: 2 Um: Each
Checked & Approved By :	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	SPRAY PAINTING	SPRAY PAINTING
-----	----------------	----------------



Comment: SPRAY PAINTING EAGLE:

PULL FROM STOCK:

1 X D412-776-011 (D3690-041) B41017

1 X D412-776-011 (D3690-041) B41187

EAGLE WO# 45594.1.4

EAGLE WO# 45594.1.5

SAND/SCUFF LIGHTLY TO REMOVE EXISTING PAINT

RE-PAINT PER QSI005 4.2.3

JUN 02 2009

2.0	QC14	INSPECT SPRAY PAINT
-----	------	---------------------



Comment: INSPECT SPRAY PAINT

JUN 02 2009

3.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL / ORDER ENTRY:

SEND NEW ARC'S

4.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion





4.2.3 Paint – Glareshield D3690-041

4.2.3.1 The following products are acceptable:

Surface Preparation:

- BASF Glasurit plastic cleaner 541-30

Adhesion Promoter:

- BASF 865 adhesion promoter (preferred)

Sealant:

- BASF transparent filler 285-60 : Mix the sealer as follows :
 - Add 2 parts of 285-60
 - Add 1 part of 929-53
 - Add 30% by mixed volume of 352-50 reducer
 - Stir and let settle for 10 minutes

Topcoat:

- BASF Glasurit 22-Line, urethane flat Dart black, color code SFA39.50 (CSO: custom mix) paint. Ensure the color is a CSO mix, and mixed as follows. Note a per gallon ratio is exemplified:

	<u>Individual Quantity</u>	<u>Cumulative Quantity</u>
• M0	187.10g	187.10g
• M26	946.80g	1133g
• M5	30.40g	1164g
• M6	8.10g	1172.4g
• M60	33.50g	1205.9g
• 522-300	2508.20g	3714.1g
• Totaling	3714.10g	

- Ensure to mix the SFA39.50 as follows to achieve the correct mixing for spraying, and for the proper final finish:
 - Add 3 parts SFA39.50 flat black
 - Add 1 part 929-91 activator
 - Add 20% by mixed volume of 352-50 reducer
 - Stir and let settle for 10 minutes

4.2.3.2 Surface Preparation:

- The surface must first be cleaned using BASF Glasurit 541-30. Evenly wash all surfaces and corners using a clean soft lint free rag, followed by a dry clean soft lint free rag.
- Ensure the part surface is no longer slick to the touch. If the surface is still slick, repeat.
- Evenly dry sand the painted surface using a 400 to 600 grit dry paper or a maroon 3M scotchbrite pad. Ensure all corners and edges are scuffed for proper adhesion, until gloss finish has been removed, and there are no burrs on the surface or edges caused by sanding.
- Blow off any dust or sanding particles.
- Clean the surface to be painted using BASF Glasurit 541-30 as noted above.



4.2.3.3 Adhesion Promoter:

- Prepare the adhesion promoter as per manufacturer's instructions.
- Apply one even coat over the entire part and allow a flash time of 20 minutes.
- Apply sealer per section 4.2.3.4

4.2.3.4 Sealing:

- Prepare the transparent filler sealer as per section 4.2.3.1
- Apply one coat evenly over the surface being painted. Allow approximately 20 minutes flash time before top coating.

4.2.3.5 Topcoat:

- Ensure the SFA39.50 is mixed in accordance with section 4.2.3.1 as it will affect the final finish.
- Apply the topcoat evenly over the parts surface. Ensure the gun regulator is set correctly for paint mixture type.
- Allow paint flash time of 10 minutes before applying the next coat.
- The total film thickness **should not exceed** 4 mils. When the thickness is exceeded, the flexibility of the paint decreases.
- Allow product to harden to the point where it will not be disturbed in further operations (approximately 12 to 15 hours).

Work Order Number: 45594

Dart General Shop

This Work Report forms part of this aircraft's permanent technical records - DO NOT DESTROY.

Item: 1 General Shop

Squawk: 1.1

Discrepancy:

Mount Flashlight clips to angle for testing flashlight mounting.

Material spec not significant.

1.1 Work Done By: Harvey Siemens

Resolution:

D412-791 JAR OPS 3 kit

Clips mounted for testing.

Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
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Squawk: 1.2

Discrepancy:

Install 407 floor protector in aft cabin

D407-781

Test Fit clear 407/206L floor protector

1.2 Work Done By: Ken Moore

Resolution:

407 cabin floor protector installed and adjusted.

Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
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Squawk: 1.3

Discrepancy:

Mount tail boom aft nav light fairing on tailboom for testing

D412-750

1.3 Work Done By: Harvey Siemens

Resolution:

Nav light fairing installed and removed as required

Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
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Squawk: 1.4

Discrepancy:

Repaint Glareshield p/n D412-776-011 b/n 41017 (installed on C-FNOS) per Dart QSI 005 sections 4.2.3.

1.4 Work Done By: Ken Moore

Resolution:

Glareshield p/n D412-776-011 b/n 41017 (installed on C-FNOS) repainted per Dart QSI 005 sections 4.2.3.

The maintenance described above has been performed in accordance with the applicable standards of airworthiness.

AMO 6-81 Signature: Dan Lemay on 5/25/2009

Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
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***** Original Maintenance Releases and Independent Control Inspection details are stored electronically at *****

***** Eagle Copters Maintenance Ltd. in Calgary Alberta in the Corridor Software *****

Work Order Number: 45594

Dart General Shop

This Work Report forms part of this aircraft's permanent technical records - DO NOT DESTROY.

Squawk: 1.5

Discrepancy:

Repaint Glareshield p/n D412-776-011 b/n 41187 (installed on C-FZQB) per QSI 005 section 4.2.3

Resolution:

Glareshield p/n D412-776-011 b/n 41187 (installed on C-FZQB) repainted per QSI 005 section 4.2.3

1.5 Work Done By: Ken Moore

The maintenance described above has been performed in accordance with the applicable standards of airworthiness.
AMO 6-81 Signature: Dan Lemay on 5/25/2009

Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
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Squawk: 1.6

Discrepancy:

Develop Aft Cabin Wall Protectors

Resolution:

See Squawk 1.11

1.6 Work Done By: Dan Lemay

Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
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Squawk: 1.8

Discrepancy:

Modify RH spacepod for installation on EC130

Resolution:

1.8 Work Done By:

Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
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Squawk: 1.9

Discrepancy:

Prepare NOS for baggage compartment protectors for testing. See Harvey.

Resolution:

1.9 Work Done By:

Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
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Squawk: 1.10

Discrepancy:

Install baggage compartment protectors in C-FNOS tailboom baggage compartment per IIN-D412-760 Section 3.7

Resolution:

Baggage compartment protectors installed per IIN-D412-760 Section 3.7

1.10 Work Done By: Jason Chanthvong

The maintenance described above has been performed in accordance with the applicable standards of airworthiness.
AMO 6-81 Signature: Colin Gould on 5/12/2009

Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
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